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**McCarty**

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(54) **MULTI-PIECE FLOW CONTROL APPARATUS  
FOR USE WITH FLUID VALVES**

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CPC .... **F16K 1/36** (2013.01); **F16K 1/48** (2013.01)

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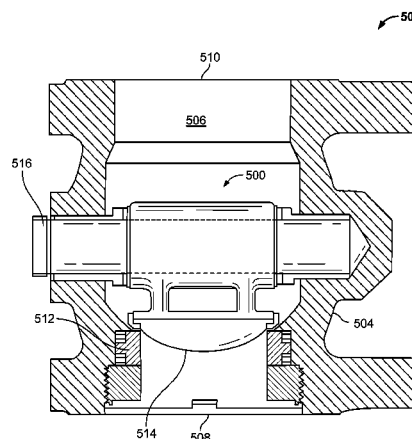
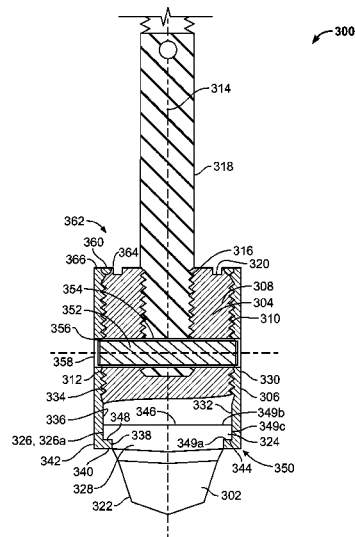
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**ABSTRACT**

Multi-piece flow control apparatus for use with fluid valves  
are described. An example flow control apparatus described  
herein includes a sleeve having first and second ends, the first  
end including a lip. A valve plug tip is disposed in the sleeve  
and has a shoulder engaged with an inner surface of the lip. An  
insert is disposed in the second end of the sleeve and engaged  
with the valve plug tip to urge the shoulder of the valve plug  
tip against the inner surface of the lip. The insert has an  
opening to receive a stem of the valve.

**17 Claims, 6 Drawing Sheets**



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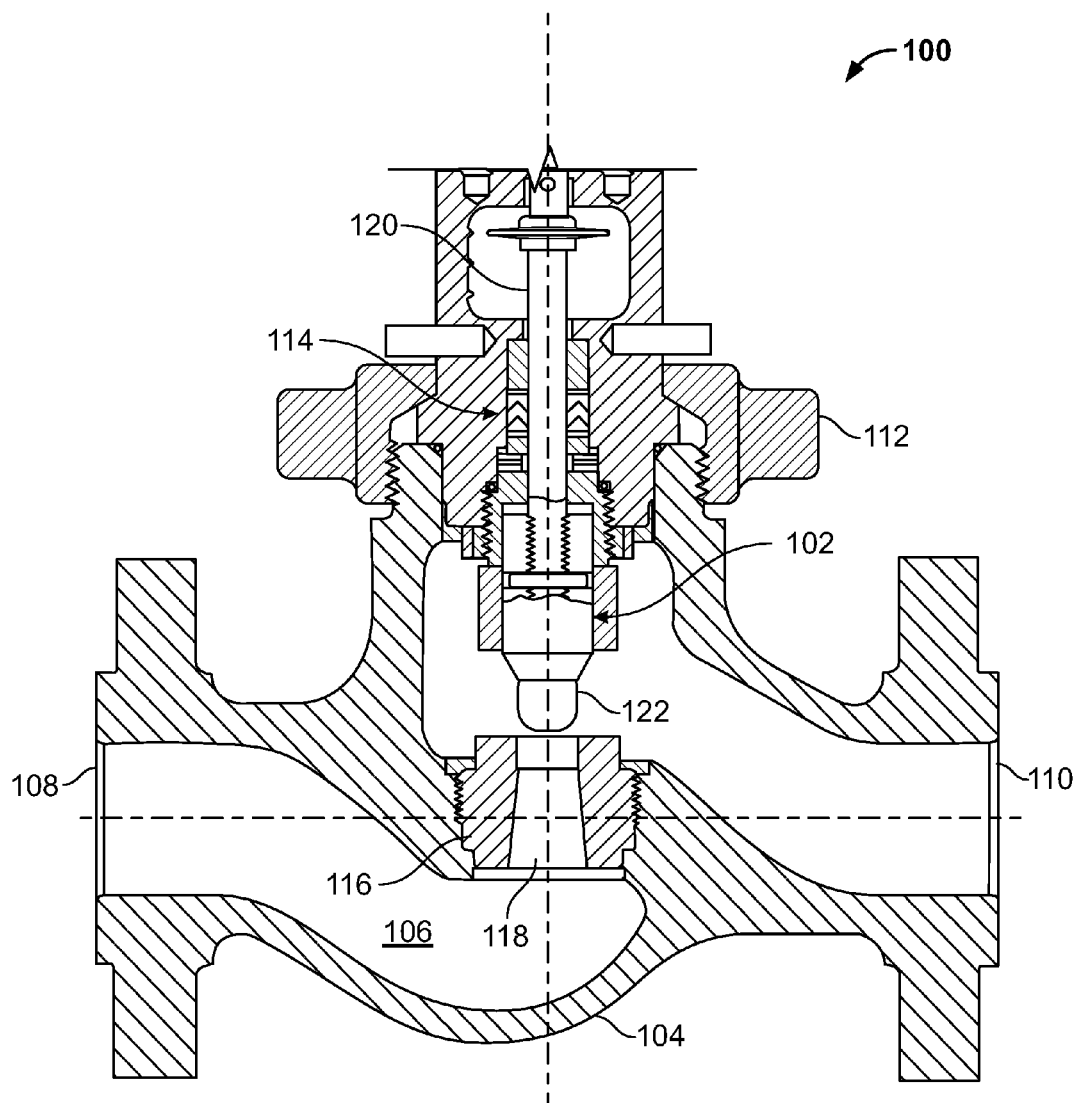
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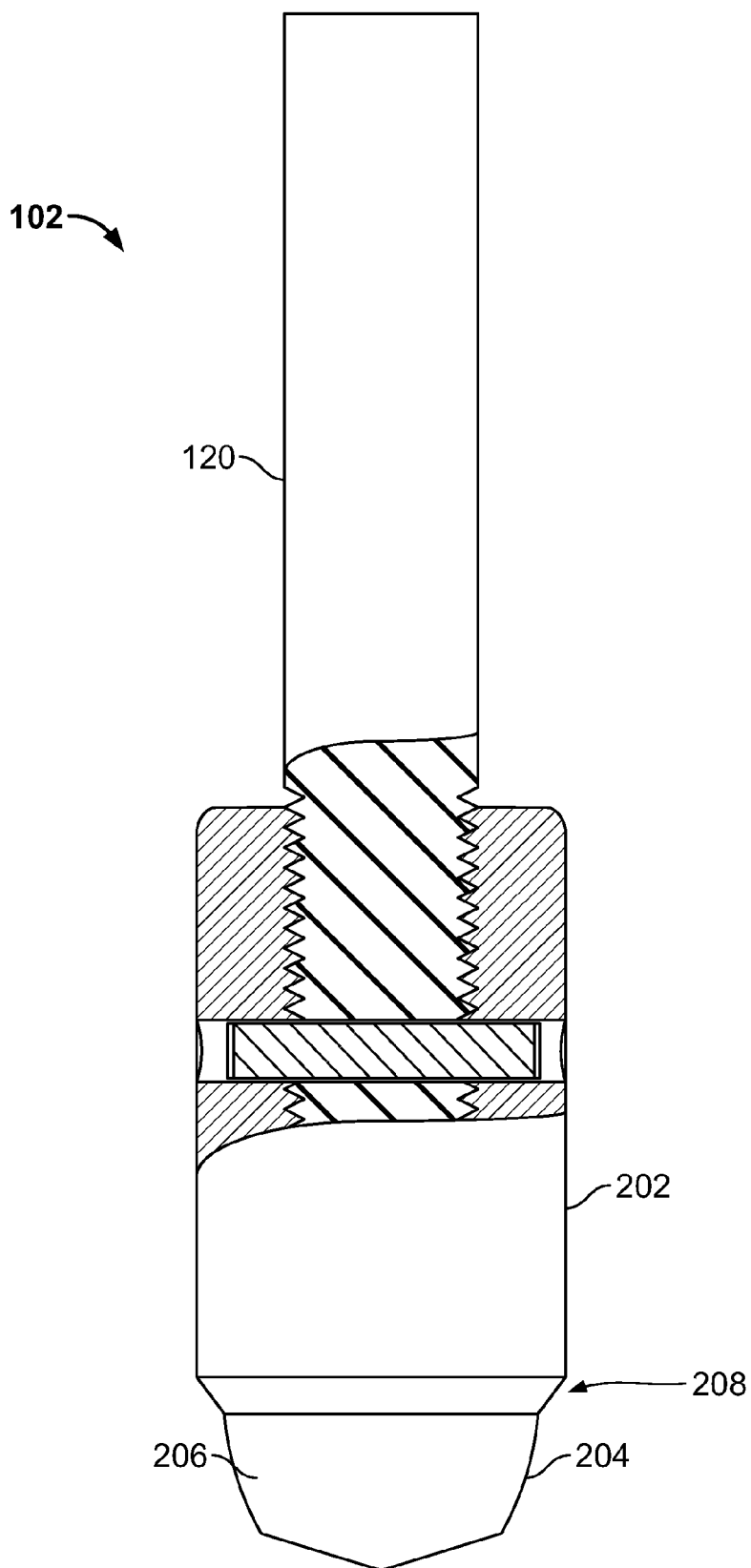
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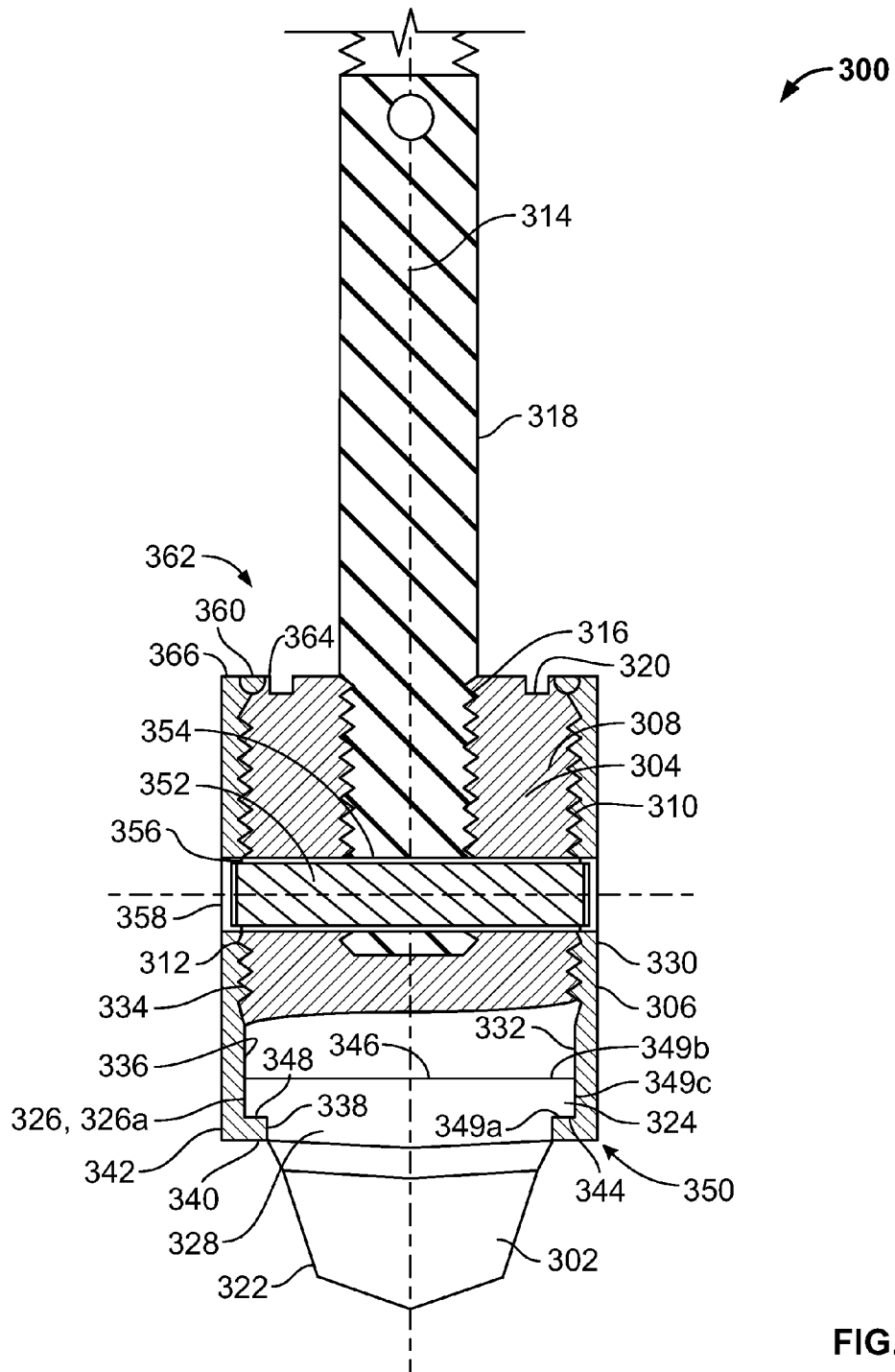
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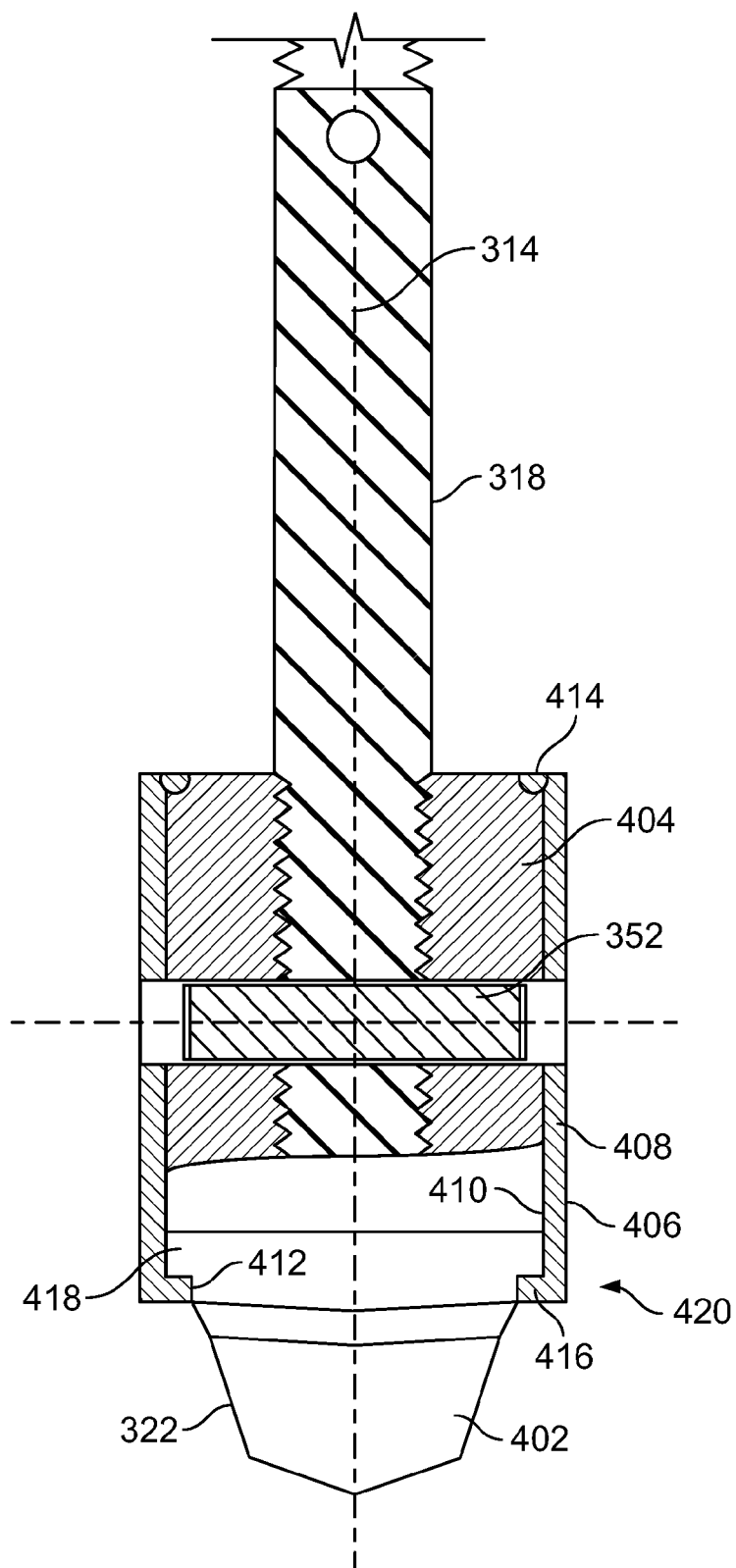
**FIG. 1**  
**Prior Art**



**FIG. 2**  
**(Prior Art)**



**FIG. 3**



**FIG. 4**

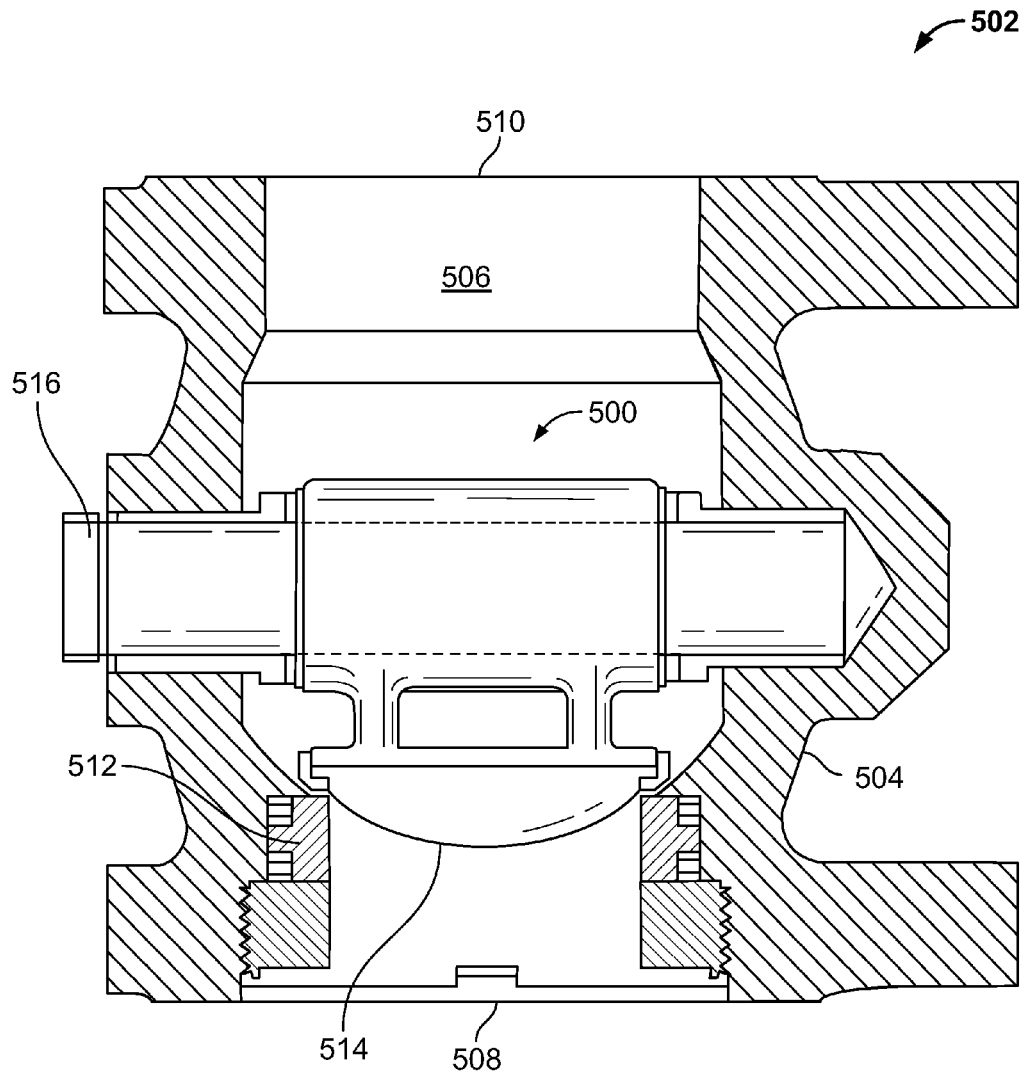
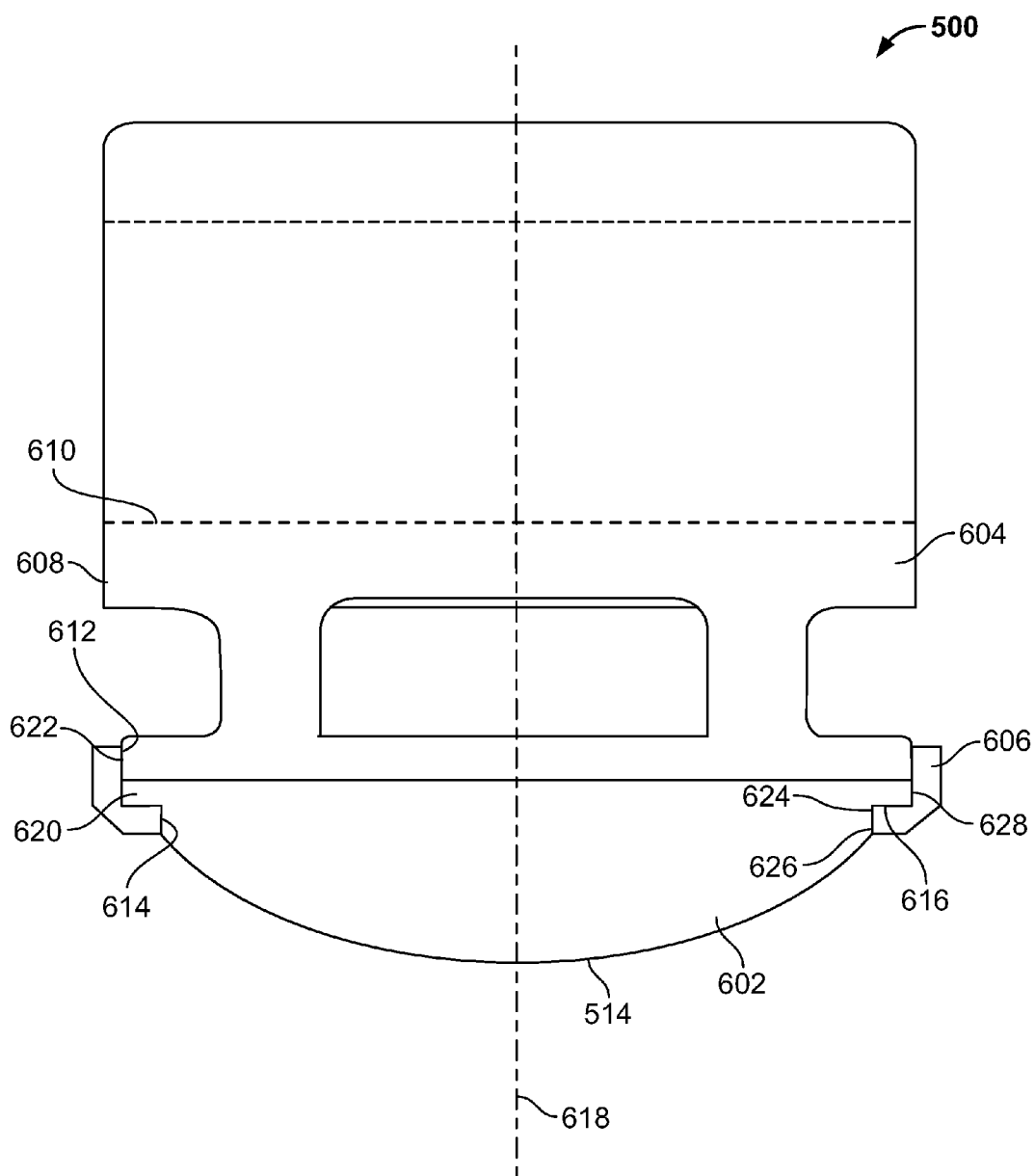


FIG. 5



**FIG. 6**



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# MULTI-PIECE FLOW CONTROL APPARATUS FOR USE WITH FLUID VALVES

## FIELD OF THE DISCLOSURE

This disclosure relates generally to control valves and, more particularly, to multi-piece flow control apparatus for use with fluid valves.

## BACKGROUND

Fluid valves are often used in process control plants or systems to control the flow of process fluids. In general, fluid valves typically include a valve trim assembly or apparatus that includes a valve plug (e.g., a metal valve plug) and a valve seat (e.g., a metal seat ring) that are disposed in a fluid path to control the flow of fluid through a passageway between an inlet and an outlet. A valve stem or shaft operatively couples the valve plug to an actuator such as, for example, a pneumatic actuator, a manual actuator, etc. The actuator moves the valve plug between an open position at which the valve plug is spaced from the valve seat to allow fluid flow through the passageway and a closed position at which the valve plug sealingly engages the valve seat to restrict or prevent fluid flow through the passageway.

In severe service applications such as, for example, in the petrochemical industry, control valves may be subjected to severely erosive fluid conditions that can rapidly wear or reduce the operating life of the valve trim (e.g., a valve plug, etc.). For example, the valve trim may be exposed to flowing process fluids that contain entrained particulate (e.g., ceramic catalyst fines). Valve plugs having tungsten carbide tips are often employed in severe service applications to reduce damage and/or wear caused by severely erosive process fluids that may otherwise damage metallic valve plugs, thereby increasing the operating life of the valve plug.

## SUMMARY

In one example, a multi-piece flow control apparatus includes a sleeve having first and second ends, the first end including a lip. A valve plug tip is disposed in the sleeve and has a shoulder engaged with an inner surface of the lip. An insert is disposed in the second end of the sleeve and engaged with the valve plug tip to urge the shoulder of the valve plug tip against the inner surface of the lip. The insert has an opening to receive a stem of the valve.

In another example, a flow control apparatus includes a cylindrical housing and a valve plug tip disposed in the cylindrical housing. An insert is disposed in the cylindrical housing to capture the valve plug tip between an inner surface of the cylindrical housing and the insert.

## BRIEF DESCRIPTION OF THE DRAWINGS

FIG. 1 illustrates a known fluid valve implemented with a known valve plug apparatus.

FIG. 2 is an enlarged view of the known valve plug apparatus of FIG. 1.

FIG. 3 illustrates a partial cross-sectional view of an example flow control apparatus described herein that may be used with a fluid valve.

FIG. 4 illustrates a partial cross-sectional view of another example flow control apparatus described herein that may be used with fluid valve.

FIG. 5 illustrates another example flow control apparatus described herein that may be used with a rotary fluid valve.

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FIG. 6 is an enlarged view of the example flow control apparatus of FIG. 5.

## DETAILED DESCRIPTION

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In general, the example flow control apparatus described herein may be used with severely erosive and/or relatively high viscosity process fluids such as, for example, process fluids (e.g., gritty fluids, gases, etc.) having entrained particulate (e.g., ceramic catalyst, sand, debris, etc.) and the like that can cause damage or erosion to conventional valve plug apparatus. In particular, an example flow control apparatus described herein has a significantly greater operating life compared to conventional valve plugs. More specifically, the example flow control apparatus described herein have a significantly stronger connection between, for example, a flow control body and a valve plug tip (e.g., a tungsten carbide tip). Additionally, the example flow control apparatus described herein facilitate manufacturing or assembly of a multi-piece flow control apparatus composed of different materials.

One example flow control apparatus described herein includes a multi-piece flow control member having a first portion or valve plug tip removably coupled to an insert or base via a retainer, sleeve or fastener. The retainer or sleeve traps, captures, secures or otherwise retains the valve plug tip relative to the insert. The valve plug tip may be composed of a first material and the insert may be composed of a second material different than the first material. The retainer or sleeve provides a relatively stronger connection or joint between the valve plug tip and the insert compared to, for example, conventional valve plugs that use sintering, brazing or other similar manufacturing techniques or processes to provide a connection between a conventional valve plug tip and a conventional insert or valve plug body. Thus, the example flow control apparatus described herein eliminates brazing or sintering processes and provides a drop-in insert that is trapped or captured between an insert or valve plug body and a retainer or sleeve.

The valve plug tip of the example flow control apparatus described herein may be composed of a material for use in severely erosive fluids such as, for example, relatively high viscosity fluids and/or fluids containing particulate (e.g., ceramic catalyst fines). Further, the sleeve or retainer provides a joint or connection that significantly reduces or prevents the connection between the valve plug tip and the insert from fracturing, cracking or otherwise becoming damaged during operation, assembly, manufacturing, shipping, etc. More specifically, the connection captures the valve plug tip and the insert such that the retainer or sleeve provides a compressive force to the valve plug tip and the insert while significantly reducing or providing negligible tensile stresses at the connection between the valve plug tip and the insert. Additionally, an example flow control apparatus described herein may be factory installed or may be retrofit to existing valves in the field.

FIG. 1 illustrates a known fluid valve **100** having a known valve plug apparatus **102** that may be used in severe service applications (e.g., severely erosive process fluid, high pressure applications, etc.). Referring to FIG. 1, the example fluid valve **100** includes a valve body **104** that defines a fluid flow passageway **106** between an inlet **108** and an outlet **110**. A bonnet **112** is coupled (e.g., threadably coupled) to the valve body **104** and couples the valve body **104** to an actuator (not shown). The bonnet **112** also houses a packing system **114** to prevent leakage of process fluid to the environment.

A valve seat or seat ring **116** is disposed within the passageway **106** to define an orifice **118**. The valve plug apparatus

tus **102** is disposed within the fluid flow passageway **106** and is operatively coupled to an actuator via a valve stem **120**.

In operation, an actuator (e.g., a pneumatic actuator, an electric actuator, a hydraulic actuator, a manual actuator, etc.) moves the valve plug apparatus **102** via the valve stem **120** relative to the seat ring **116** to control fluid flow through the passageway **106** between the inlet **108** and the outlet **110**. In particular, the valve plug apparatus **102** moves between a closed position at which the valve plug apparatus **102** is sealingly engaged with the seat ring **116** to prevent or restrict fluid flow through the passageway **106** between the inlet **108** and the outlet **110** and a fully open or maximum flow position at which the valve plug apparatus **102** is spaced away from the seat ring **116** to allow fluid flow through the passageway **106** between the inlet **108** and the outlet **110**.

In severe service applications (e.g., petrochemical applications), the valve plug apparatus **102** may be exposed to severely erosive and/or corrosive fluid conditions or the like that can rapidly wear or cause material loss and significantly reduce the operating life of the valve plug apparatus **102**. For example, the valve plug apparatus **102** may be exposed to process fluids entrained with particulate (e.g., ceramic catalyst fines) or relatively high viscosity fluids, which can wear or degrade a surface or tip **122** of the valve plug apparatus **102**. Thus, in severely erosive fluid conditions, valve plugs having inserts made of tungsten carbide materials, ceramic materials, etc. are often employed because such materials have relatively high resistance to erosive or corrosive fluid conditions, thereby increasing the operating life of the valve plug apparatus **102**.

FIG. 2 illustrates the known valve plug apparatus **102** of FIG. 1. Referring to the example of FIG. 2, the valve plug apparatus **102** includes a valve plug body or insert **202** having a tungsten carbide tip **204** to protect an end or surface **206** of the valve plug body **202** that is in direct fluid contact with the fluid from adverse process effects such as, for example, abrasion, erosion, corrosion, etc.

The material properties of tungsten carbide are not suitable for welded or threaded joints. As a result, the tungsten carbide tip **204** is typically coupled to the valve plug body **202** via, for example, sintering or brazing manufacturing process(es). When sintered or brazed, the valve plug body **202** and the tungsten carbide tip **204** form a connection **208**. However, using sintering or brazing manufacturing techniques often causes the connection **208** to be brittle and/or provides a significant amount of tensile stresses at the connection **208**. Such a brittle connection and/or the tensile stresses at the connection **208** may cause the tungsten carbide tip **204** to break, fracture, crack or otherwise become damaged and cause the tip **204** to disengage or detach from the valve plug body **202**. The valve plug apparatus **102** exposed to particulate and/or highly viscous fluid in this manner becomes ineffective at controlling fluid flow through the fluid valve **100**. As a result, sintering or brazing the valve plug body **202** and the tungsten carbide tip **204** results in a significantly reduced operating life of the valve plug apparatus **102**. Further, the complexity of sintering and brazing manufacturing processes often leads to low quality, low yield products because the connection **208** is often weak or brittle and, thus, is susceptible to cracking, fracturing, etc. For example, the tungsten carbide tip **204** may break or detach at the connection **208** during, for example, a cooling process of the valve plug apparatus **102** when the tungsten carbide tip **204** is coupled to the valve plug body **202**, during shipment of the product, during operation, etc.

FIG. 3 illustrates an example multi-piece valve plug or flow control apparatus **300** described herein that can be used with

a fluid valve such as, for example, the fluid valve **100** of FIG. 1. In particular, the flow control apparatus **300** described herein may be employed in severely erosive or corrosive applications such as, for example, applications involving relatively highly viscous process fluids and/or process fluids entrained with particulate (e.g., ceramic catalyst fines) or other contaminants.

Referring to FIG. 3, the flow control apparatus **300** includes a valve plug tip **302** coupled to an insert or base **304** via a retainer or sleeve **306** (e.g., a multi-piece valve plug assembly). In this example, the insert **304** is composed of a first material (e.g., stainless steel) and the valve plug tip **302** is composed of a second material different than the first material (e.g., tungsten carbide).

The insert **304** of FIG. 3 includes a cylindrically-shaped body **308** having a threaded portion **310** along an outer surface **312** of the body **308** that extends in a direction along an axis **314** of the insert **304**. The insert **304** of the illustrated example also includes an aperture **316** (e.g., a threaded opening) to receive a valve stem **318** that couples the flow control apparatus **300** to, for example, an actuator (not shown). In other examples, the insert **304** and the valve stem **318** may be a unitary piece or structure. In yet other examples, the valve stem **318** may be coupled to the insert **304** via a tack weld, a pin, a fastener or any other suitable fastening mechanism(s). As described below, the insert **304** of FIG. 3 may include one or more openings, recesses or features **320** adjacent the valve stem **318** and the outer surface **312** of the insert **304**. In the illustrated example of FIG. 3, the insert **304** is composed of stainless steel. However, in other examples, the insert **304** may be composed of an alloy, a metal, or any other suitable material(s).

The valve plug tip **302** has a sealing surface **322** to engage a seating surface of a valve seat (e.g., the valve seat **116** of FIG. 1) when the flow control apparatus **300** is coupled to a fluid valve (e.g., the fluid valve **100** of FIG. 1). The valve plug tip **302** includes an engagement surface **324** adjacent the seating surface **322** that is depicted as a flange **326** (e.g., an annular flange) in the illustrated example of FIG. 3. In particular, the valve plug tip **302** of the illustrated example is a cylindrical body **328** having an annular flange **326a**. The sealing surface **322** extends away from the body **328** and the annular flange **326a**, and tapers toward the longitudinal axis **314** of the insert **304**. In this example, the valve plug tip **302** is composed of a tungsten carbide material. However, in other examples, the valve plug tip **302** may be composed of a metallic material or alloy, a ceramic material and/or any other suitable material(s) having relatively high resistance to erosive or corrosive fluid conditions.

As noted above, the retainer **306** removably couples, traps, secures or retains the valve plug tip **302** and the insert **304**. In this manner, the valve plug tip **302** may be interchanged or replaced with another valve plug tip that is substantially similar to the valve plug tip **302** of FIG. 3. Additionally or alternatively, the valve plug tip **302** of FIG. 3 may be replaced or interchanged with a valve plug tip that is different than the valve plug tip **302**. For example, a valve plug tip coupled to the insert **304** may be composed of a ceramic material and can be replaced or interchanged with another valve plug tip composed of, for example, tungsten carbide material or any other material for use in highly erosive fluid conditions. Further, the valve plug tip **302** of FIG. 3 facilitates manufacturing and significantly reduces costs by eliminating brazing and sintering manufacturing process(es) and facilitating assembly of the flow control apparatus **300**.

In the illustrated example of FIG. 3, the retainer **306** is a threaded fastener or nut. As shown in FIG. 3, the sleeve or

retainer 306 has a retainer body 330 (e.g., a cylindrical body) that defines a cavity 332 sized to receive at least a portion of the insert 304. The retainer 306 includes a threaded portion 334 along a length of an inner surface or wall 336 of the cavity 332 of the retainer body 330 to engage the threads of the insert 304. The retainer 306 also includes an opening 338 coaxially aligned with the cavity 332 to receive the seating surface 322 of the valve plug tip 302. In other words, a diameter of the opening 338 is greater than a diameter of the seating surface 322 but less than an outer diameter of the flange 326.

Additionally, the retainer 306 includes a lip, shoulder or support surface 340 adjacent an end 342 of the retainer body 330. In this example, the lip 340 forms a shoulder 344 defined by a diameter of the cavity 332 being greater than a diameter of the opening 338. The lip 340 as depicted in FIG. 3 is an annular lip that is integrally formed with the retainer body 330 as a unitary piece or structure. In other examples, the lip 340 may be a plurality of protruding members radially spaced about the axis 314 and inwardly protruding from the retainer body 330 toward the axis 314.

During assembly, the valve plug tip 302 is at least partially disposed within the cavity 332 of the retainer 306 so the seating surface 322 of the valve plug tip 302 at least partially extends through the opening 338 of the retainer 306. The lip 340 of the retainer 306 supports or engages the engagement surface 324 of the valve plug tip 302 when the valve plug tip 302 is coupled to (e.g., disposed within the cavity 322) the retainer 306. The retainer 306 and the valve plug tip 302 are then coupled to the insert 304. For example, the retainer 306 and the valve plug tip 302 are coupled to the insert 304 after the insert 304 has been coupled to the valve shaft 318. In other examples, the retainer 306 and the valve plug tip 302 may be coupled to the insert 304 prior to the insert 304 being attached or coupled to the valve stem 318. In the illustrated example, the retainer 306 is fastened or threaded to the body 308 of the insert 304.

When the valve plug tip 302 is coupled to the insert 304 via the retainer 306, an inner surface 348 of the lip 340 (e.g., substantially perpendicular to the surface 336) engages a first side 349a of the engagement surface 324 of the valve plug tip 302 and a surface 346 of the insert 304 engages a second side 349b of the engagement surface 324 to retain or capture the engagement surface 324 between the insert 304 and the retainer 306. In particular, the lip 340 of the retainer 306 and/or the insert 304 apply a force (e.g., a compressive force) against the engagement surface 324 in a direction (e.g., a vertical direction) along the axis 314 when the retainer 306 is fastened to the insert 304 to prevent the valve plug tip 302 from moving relative to the insert 304 and/or the retainer 306.

Further, in the illustrated example, when coupled to the flow control member 300, the inner surface 336 of the retainer 306 engages a third side 349c of the engagement surface 324 of the valve plug tip 302 with a relatively tight fit or tolerance to prevent or significantly reduce movement or play of the valve plug tip 302 relative to the insert 304 and/or the retainer 306. Additionally, the surface 348 of the lip 340 (e.g., parallel to the surface 336) engages the body 328 of the valve plug tip 302. As a result, the retainer 306 applies a compressive force against the valve plug tip 302 in a direction substantially perpendicular to the axis 314. However, in other examples, the side 349c may be spaced away from the inner surface 336.

Thus, when coupled to the insert 304, the engagement surface 324 engages the lip 340, the inner surface 336 of the retainer 306, and the surface 346 of the insert 304 with a relatively tight fit to prevent movement of the valve plug tip 302 relative to the retainer 306 and/or the insert 304. As a result, in this example, the retainer 306 applies both a radial

compressive force relative to the axis 314 and an axial compressive force relative to the axis 314 when the retainer 306 is coupled to the insert 304.

In other examples, the retainer 306 is coupled to the valve plug tip 302 via shrink fit, press fit and/or any other suitable manufacturing process(es). For example, the retainer 306 may be heated so that it expands, the valve plug tip 302 may be disposed within the cavity 332 of the retainer 306 so that at least a portion of the seating surface 322 extends through the opening 338, and the retainer 306 may be cooled. When the retainer 306 cools, the retainer 306 contracts to capture, surround or retain (e.g., the flange 326 of) the valve plug tip 302 with a relatively tight fit. In other examples, the valve plug tip 302 may be press-fit within the cavity of the retainer 306 so that the retainer 306 engages or retains the valve plug tip 302 with a relatively tight fit. When the retainer 306 is shrink fit or press fit with the valve plug tip 302, the retainer 306 captures the valve plug tip 302 to provide or apply a compressive force to the valve plug tip 302 in a direction substantially perpendicular to the axis 314. Thus, in this example, the retainer 306 provides a compressive force on an outer surface(s) (e.g., the surface 349c, the body 328) of the valve plug tip 302 in a radial direction toward the axis 314. Additionally or alternatively, the insert 304 may be press-fit and/or shrink fit with the retainer 306 and valve plug tip 302 assembly to couple or secure the insert 304 and the retainer 306.

Thus, unlike the connection 208 of FIG. 2, the retainer 306 and the insert 304 form a connection 350 that provides compressive stresses or forces. Further, the connection 350 provides negligible tensile stresses or forces between the valve plug tip 302 and the insert 304. As a result, the connection 350 is significantly stronger or more robust than, for example, the connection 208 of FIG. 2 and prevents or significantly reduces the likelihood of the valve plug tip 302 disengaging from the insert 304 during operation, manufacturing, shipping, etc. Additionally, during assembly, when the retainer 306 is coupled to the insert 304, a tool such as a spanner tool may be disposed within the openings 320 to rotatably fix the insert 304 relative to the retainer 306 when threading the retainer 306 onto the insert 304 to enable, for example, applying a desired torque to the retainer 306 when fastening the retainer 306 to the insert 304.

Additionally, a pin 352, or any other fastening method such as, for example, tack welding, may be used to prevent the valve stem 318 from rotating and backing out of and/or moving further into the insert 304. As shown in FIG. 3, the pin 352 is disposed within an opening or passageway 354 of the valve stem 318 that is coaxially aligned with respective openings or passageways 356 and 358 of the insert 304 and the retainer 306. In this example, the respective openings 356 and 358 of the insert 304 and the retainer 306 are coaxially aligned with the opening 354 of the valve stem 318 and substantially perpendicular to the axis 314. In other examples, the pin 352 is not required.

Further, a seal weld 360 may be disposed about a periphery of an insert/retainer interface 362 between respective surfaces 364 and 366 of the insert 304 and the retainer 306 to prevent the retainer 306 from rotating or unthreading relative to the insert 304 due to, for example, vibration(s) during operation. The seal weld 360 may be an annular weld or one or more spot welds radially disposed relative to the axis 314 about the periphery of the interface 362.

To remove the valve plug tip 302 from the insert 304, for example, in the field, the pin 352 is removed from the openings 354, 356, 358 and the seal weld 360 is removed from insert/retainer interface 362. The retainer 306 is threadably decoupled from the insert 304 by rotating the retainer 306

relative to the insert **304** about the axis **314**. To facilitate rotation of the retainer **306** relative to the insert **304** when removing the retainer **306**, a tool (e.g., a spanner tool) may be disposed within the openings **320** adjacent the insert/retainer interface **362**. With the tool (e.g., the spanner tool) inserted in the openings **320**, an operator may hold or prevent rotation of the insert **304** when the retainer **306** is being unthreaded or rotated relative to the insert **304**. Removing the retainer **306** also removes the valve plug tip **302** from the insert **304**. Once the retainer **306** is removed, the valve plug tip **302** may be removed or detached from the retainer **306**.

In some examples, the valve plug tip **302** may be replaced or interchanged with another valve plug tip that is substantially similar to the valve plug tip **302** of FIG. **3** (e.g., a valve plug tip composed of tungsten carbide material). However, in other examples, the valve plug tip **302** may be replaced or interchanged with a valve plug tip that is substantially different than the valve plug tip **302** of FIG. **3** (e.g., a valve plug tip composed of ceramic material). In other examples, the valve plug tip **302** and retainer **306** assembly may be removed and replaced with another valve plug tip/retainer assembly.

During operation, the flow control apparatus **300** is disposed within a passageway of a valve body to control the fluid flow between an inlet and an outlet. An actuator may be operatively coupled to the flow control apparatus **300** via the valve stem **318**. Particulate and/or viscous fluid flows through the passageway and impacts the valve plug tip **302**. The valve plug tip **302**, which may be composed of tungsten carbide material, resists erosion and corrosion as particulate suspended in process fluid flows across the seating surface **322** of the valve plug tip **302**. Thus, the valve plug tip **302** resists highly erosive process conditions and the insert/retainer connection **350** prevents the valve plug tip **302** from disengaging, breaking or decoupling from the insert **304**.

FIG. **4** illustrates another example valve plug or flow control apparatus **400** described herein that may be used with a fluid valve such as, for example, the fluid valve **100** of FIG. **1**. Those components of the example flow control apparatus **400** that have structures or functions that are similar or identical to the structures or functions of those components of the example flow control apparatus **300** of FIG. **3** are labeled with the same reference numbers. The description of those components of the example flow control apparatus **400** similar or identical to those components of FIG. **3** is not repeated and the interested reader may refer to the description of FIG. **3** for details relating to those components.

The flow control apparatus **400** of FIG. **4** includes a valve plug tip **402** removably coupled to an insert **404** via a retainer or sleeve **406**. In particular, the retainer **406** is a shroud or body **408** (e.g., a cylindrical body) having a cavity **410** to receive at least a portion of the insert **404** and an opening **412** to receive the valve plug tip **402**. Unlike the retainer **306** of FIG. **3**, a seal weld **414** (e.g., an annular seal weld) couples or attaches the retainer **406** and the insert **404**. In other words, the retainer **406** of FIG. **4** is a non-threaded cylindrical body that is coupled to the insert **404** via, for example, welding. The retainer **406** includes a lip **416** (e.g., an annular lip) that engages an engagement surface or flange **418** of the valve plug tip **402** to retain the valve plug tip **402** in engagement with the insert **404**. The retainer **406** is sized to provide a tight tolerance fit when coupled to the insert **404** so that the retainer **406** and/or the insert **404** provide a compressive force to the valve plug tip **402** when the retainer **406** is coupled to the insert **404** via the weld **414**. Thus, similar to the retainer **306** of FIG. **3**, the retainer **406** captures the engagement surface **418** between the lip **416** and the insert **404** with a tight fit to apply a compressive force to the engagement surface **420** in a

direction along the axis **414** to retain the valve plug tip **402** coupled to the insert **404**. As a result, the retainer **406** and the valve plug tip **402** form a connection **420** that lacks tensile stresses, thereby providing a connection that is substantially stronger than, for example, the connection joint **208** of FIG. **2**.

Although the example flow control apparatus of FIGS. **3** and **4** are depicted as flow control apparatus **300**, **400** for use with sliding stem valves, the example flow control apparatus described herein are not limited to use with sliding stem fluid valves. In other examples, fluid valves such as, for example, globe valves, rotary valves, linear valves, etc., may be employed.

FIG. **5** illustrates another example fluid flow control apparatus or assembly **500** for use with a rotary fluid valve **502**. The rotary fluid valve **502** includes a body **504** defining a fluid flow passageway **506** between an inlet **508** and an outlet **510**. The flow control apparatus **500** is disposed within the fluid flow passageway **506** and rotates or moves relative to a seat ring or valve seat **512** to control or modulate fluid flow between the inlet **508** and the outlet **510**. In particular, a seating surface **514** of the flow control apparatus **500** engages the seat ring **512** to restrict or prevent fluid flow through the passageway **506** (e.g., a closed position) and rotates or moves away from the seat ring **512** to allow fluid flow through the passageway **506** (e.g., an open position). A valve shaft **516** operatively couples the flow control apparatus **500** to an actuator (not shown), which rotates or moves the flow control apparatus **500** relative to the seat ring **512**.

FIG. **6** illustrates the example flow control apparatus **500** of FIG. **5**. The flow control apparatus **500** of FIG. **6** includes a valve plug tip **602** coupled to an insert or valve plug body **604** via a retainer or sleeve **606**. The insert **604** and the retainer **606** may be composed of, for example, stainless steel, metal, etc. and the valve plug tip **602** may be composed of, for example, tungsten carbide, ceramic, etc.

The insert **604** includes a body or portion **608** (e.g., a cylindrical body) having an opening **610** to receive the shaft **516** and is coupled or fixed (e.g., axially and rotatably fixed) to the shaft **516** via a pin, a fastener or any other suitable mechanical fastener(s). The retainer **606** is a ring-shaped shroud or fastener having a cavity defining an inner surface or wall **612**. The retainer **606** also includes an opening **614** adjacent an end of the retainer **606** and coaxially aligned with the cavity to define a lip or shoulder **616**. In particular, the lip **616** protrudes from the inner surface **612** of the retainer **606** (e.g., perpendicularly or at an angle) toward a longitudinal or central axis **618** of the retainer **606**.

The valve plug tip **602** defines the seating surface **514** (e.g., a curved surface) and has an engagement surface or flange **620** adjacent the seating surface **514**. When coupled to the retainer **606**, the valve plug tip **602** is disposed within the cavity of the retainer **606** such that the seating surface **514** extends or protrudes from the opening **614** and away from the lip **616**, and the lip **616** engages or supports the flange **620** of the valve plug tip **602**. As shown, the seating surface **514** of the valve plug tip **602** is sized to fit through the opening **614** with a relatively tight fit or tolerance. In some examples, the valve plug tip **602** is shrink fit, press fit, or coupled to the retainer **606** via any suitable manufacturing process(es).

In the illustrated example, a surface **624** of the opening **614** engages a surface or portion **626** of the valve plug tip **602** adjacent the flange **620** and the inner surface **612** of the retainer **606** engages a surface **628** of the flange **620** with a relatively tight fit. As a result, the retainer **606** applies a compressive force (e.g., a radial compressive force) to the valve plug tip **602** in a direction (e.g., a perpendicular direction) toward the axis **618** when the valve plug tip **602** is

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coupled to the retainer 606. Further, when the retainer 606 couples the valve plug tip 602 to the insert 604, the flange 620 of the valve plug tip 602 is captured between the insert 604 and the retainer 606 with a relatively tight fit or tolerance so that the retainer 606 and/or the insert 604 apply a compressive force (e.g., an axial compressive force) to the valve plug tip 602 in a direction substantially parallel to the axis 618.

The retainer 606 may be coupled to the insert 604 via threads, welding, or any other suitable manufacturing process(es) such as, for example, the examples described above in connection with FIGS. 3 and 4. For example, the inner surface 612 of the retainer 606 and an outer surface 622 of the insert 604 may include threads to removably couple the retainer 606 and the valve plug tip 602 to the insert 604.

Although certain apparatus have been described herein, the scope of coverage of this patent is not limited thereto. To the contrary, this patent covers all apparatus fairly falling within the scope of the appended claims either literally or under the doctrine of equivalents.

What is claimed is:

1. A flow control member, comprising:  
a sleeve of a rotary valve having first and second ends, the first end including a lip, the lip defining an inner surface;  
an insert disposed in the second end of the sleeve and defining an axis along the length of the insert, the insert and the sleeve defining a first threaded interface therebetween;  
a valve stem, the valve stem and the insert defining a second threaded interface therebetween; and  
a valve plug tip disposed in the sleeve and having a flange defining a shoulder, the shoulder and the inner surface perpendicular to the axis, wherein the insert has a first contact surface to engage a second contact surface of the valve plug tip to urge the shoulder of the valve plug tip against the inner surface of the lip.
2. The flow control member of claim 1, wherein the valve plug tip comprises a tungsten or ceramic material.
3. The flow control member of claim 1, wherein the insert is fixed relative to the sleeve by a weld adjacent the second end of the sleeve.
4. The flow control member of claim 1, wherein the insert includes an aperture to receive a tool to urge the insert against the valve plug tip within the sleeve.
5. The flow control member of claim 1, further comprising an aperture passing through the sleeve and the insert, the aperture to receive a pin preventing one or more of the sleeve, or the insert from rotating relative to the valve stem.
6. The flow control member of claim 5, wherein the aperture is substantially perpendicular to an opening of the insert.
7. A flow control apparatus comprising:  
a cylindrical housing having first and second ends, the first end having a lip defining an inner surface;  
a valve plug tip disposed in the cylindrical housing and having a flange defining a shoulder; and  
an insert disposed in the cylindrical housing defining an axis along a length of the insert, the shoulder and the lip perpendicular to the axis, the insert to capture the valve plug tip between an inner surface of the cylindrical housing and the insert a first surface of the insert to engage a second surface of the valve plug tip to urge the shoulder against the inner surface of the lip to provide a compressive

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sive force to the valve plug tip along a direction of the axis, wherein the flow control apparatus is part of a rotary valve.

8. A flow control apparatus of claim 7, wherein the insert is composed of a first material and the valve plug tip is composed of a second material different than the first material.

9. A flow control apparatus of claim 8, wherein the first material comprises stainless steel and the second material comprises tungsten carbide.

10. A flow control apparatus of claim 7, wherein the valve plug tip comprises a cylindrical body coupled to the flange.

11. A flow control apparatus of claim 7, wherein the cylindrical housing is composed of stainless steel.

12. A flow control apparatus of claim 7, further comprising a seal weld between the insert and the cylindrical housing to prevent rotation of the insert relative to the cylindrical housing during operation.

13. A flow control apparatus as defined in claim 7, wherein the valve plug tip is interchangeable with another valve plug tip.

14. A flow control apparatus, comprising:

means for controlling fluid flow through a rotary valve, wherein the means for controlling fluid flow comprises a valve plug tip;

means for retaining the means for controlling fluid flow; and

means for transmitting force to the means for controlling fluid flow, the means for transmitting force threadably coupled to the means for retaining and a stem of the rotary valve, wherein the means for transmitting force contacts a portion of the means for controlling fluid flow to cause a first surface of the means for controlling fluid flow to be urged against a second surface of the means for retaining, wherein the first and second surfaces are perpendicular to an axis defined along a length of the means for transmitting force.

15. A flow control apparatus as defined in claim 14, wherein the means for controlling fluid flow is composed of a first material and the means for retaining is composed of a second material different from the first material.

16. A flow control apparatus as defined in claim 14, further comprising means for securing the means for controlling fluid flow, the means for retaining, and the means for transmitting force together via an aperture through the means for controlling fluid flow, the means for retaining, and the means for transmitting force.

17. A flow control member for a valve, comprising:

a sleeve having first and second ends, the first end including a lip, the lip defining an inner surface;

an insert disposed in the second end of the sleeve and defining an axis along the length of the insert; and

a valve plug tip disposed in the sleeve and having a flange defining a shoulder, the shoulder and the inner surface perpendicular to the axis, wherein the insert has a first contact surface to engage a second contact surface of the valve plug tip to urge the shoulder of the valve plug tip against the inner surface of the lip to provide a compressive force to the valve plug tip along a direction of the axis, wherein the valve comprises a rotary valve.

\* \* \* \* \*

UNITED STATES PATENT AND TRADEMARK OFFICE  
**CERTIFICATE OF CORRECTION**

PATENT NO. : 9,316,321 B2  
APPLICATION NO. : 13/103736  
DATED : April 19, 2016  
INVENTOR(S) : Michael Wildie McCarty

Page 1 of 1

It is certified that error appears in the above-identified patent and that said Letters Patent is hereby corrected as shown below:

In the Claims

Column 9, line 59 (Claim 7): Replace the word “insert” between “the” and “a” with “insert,”

Signed and Sealed this  
Fourteenth Day of June, 2016

A handwritten signature in black ink, reading "Michelle K. Lee". The signature is written in a cursive style with a large, stylized "M" and "L".

Michelle K. Lee  
*Director of the United States Patent and Trademark Office*